

Date: Monday, 4/23/2007 1:52:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 31997	
Estimate Number : 12713	
P.O. Number : N/A	Part Number : D353641
This Issue : 4/23/2007 S.O. No. : N/A	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 4/30/2007
Checked & Approved By : <u>07.04.25</u>	Qty: 20 Um: Each
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.7144 sf(s)/Unit Total : 14.2884 sf(s)

NEOPRENE SHEET 0.063

Batch: M103/04

SAD

07/05/03

20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: AProg Rev: A

2-Deburr if necessary

SAD 07/05/03

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/03

20

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

BC 07-05-04

20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

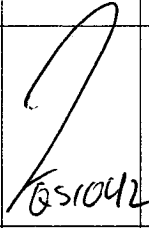

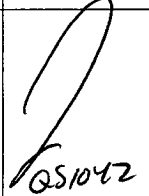

Identify and Stock

Location: Prishac

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3536-841 PAR #: Fault Category: Prod / engine ^{Card not} NCR: Yes No DQA: AD Date: 07/05/07
 QA: N/C Closed: AD Date: 07/05/08

NCR: <u>31997</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/04	2.0	wrong						
07/05/04	2.0	Dimensions were not correct Dxf mild error. IT had the remainder of the material for the wear plate Toggle.		Scrap - destroy - replace Dxf corrected.	SAD 07/05/04			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31997

Part Number: D353641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



2d

Comment: FINAL INSPECTION/W/O RELEASE

Dis 05/08

Job Completion



Ul 07-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

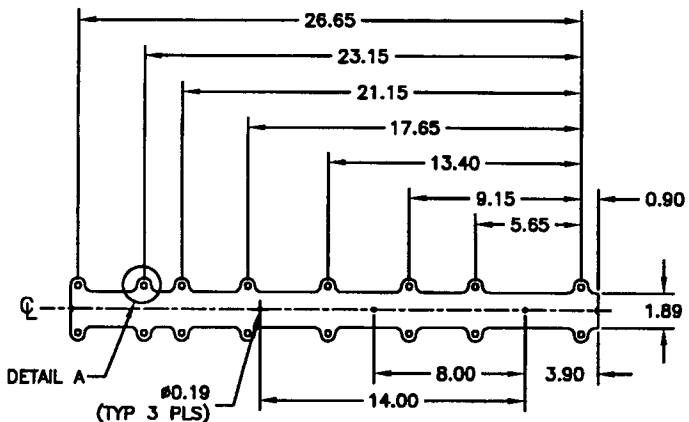
NOTE: Date & initial all entries

DART

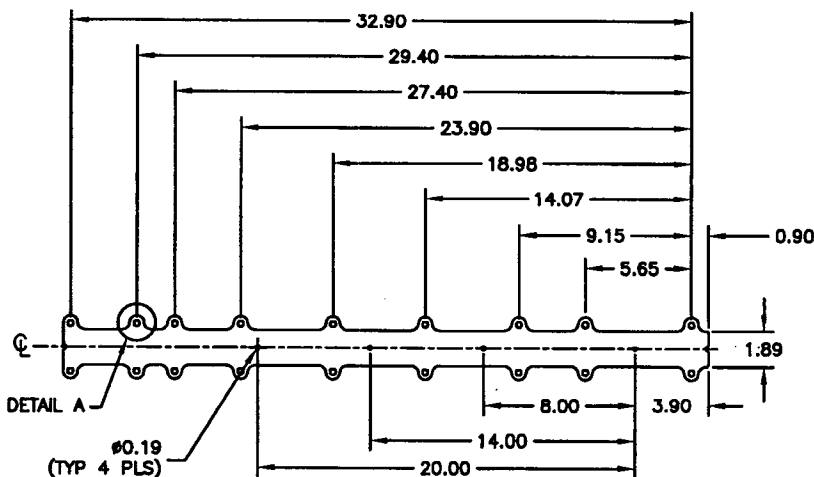
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09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AT	APPROVED	AT	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
A	06.10.25	GASKET	NEW ISSUE	SHEET 1 OF 8
				SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

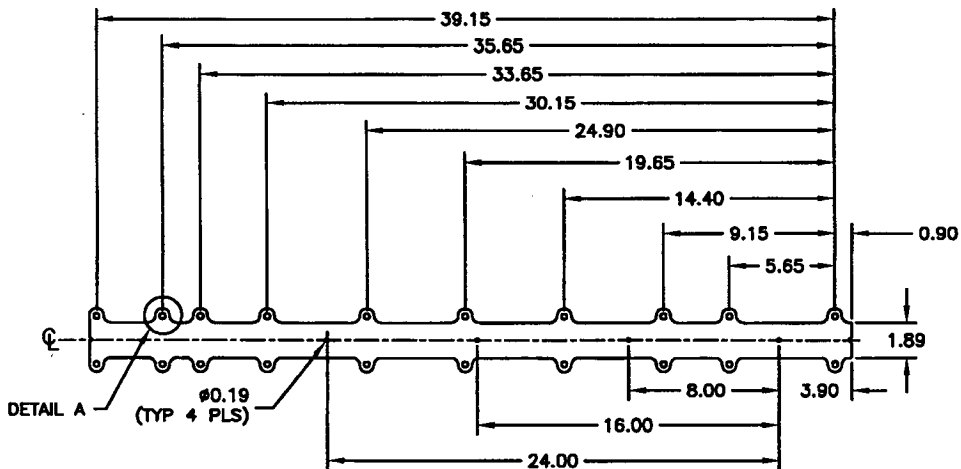
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WORK ORDER
NO. 31997

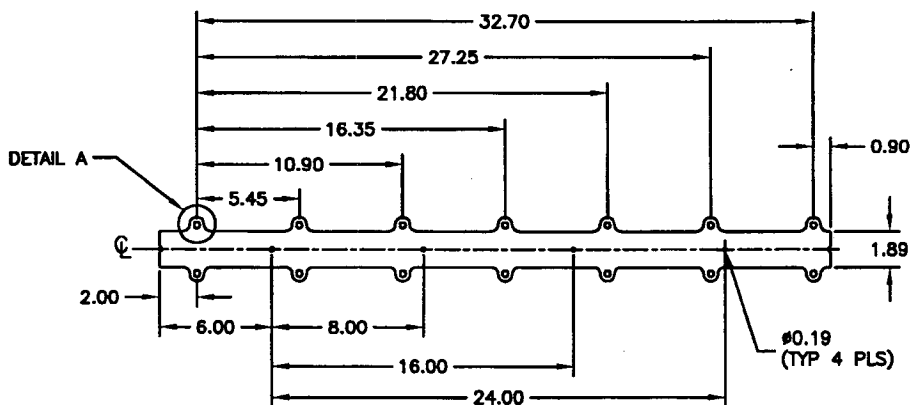


DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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07.02.12



D3536-15 GASKET



D3536-21 GASKET

NOTES

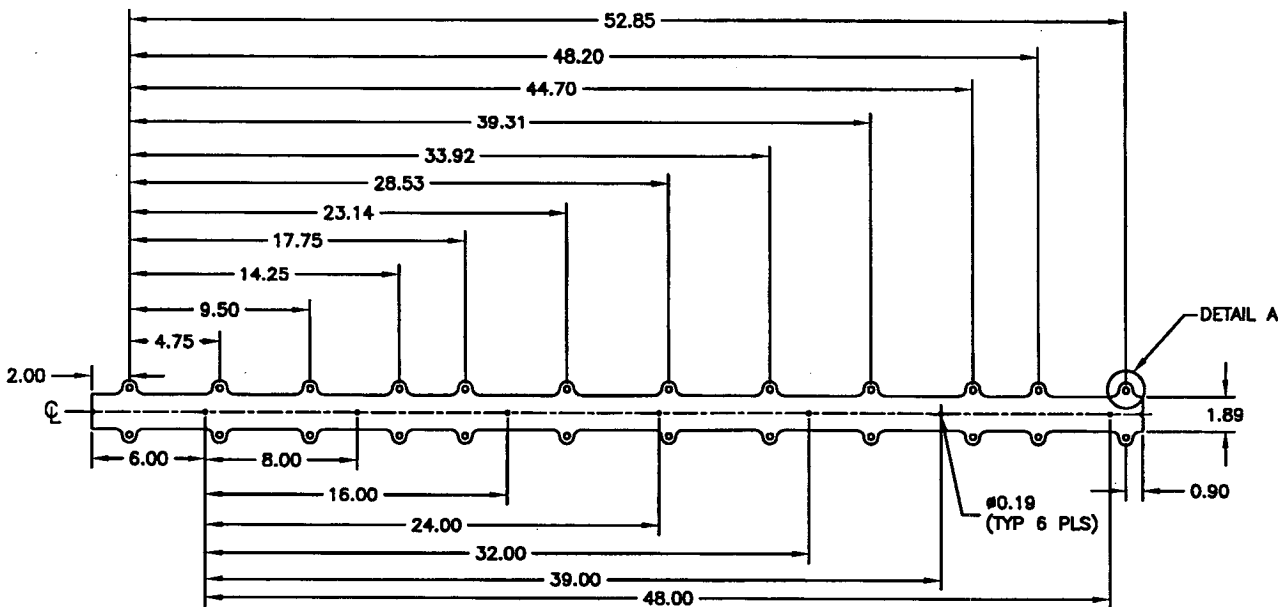
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- 2) FINISH: NONE
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WORK ORDER
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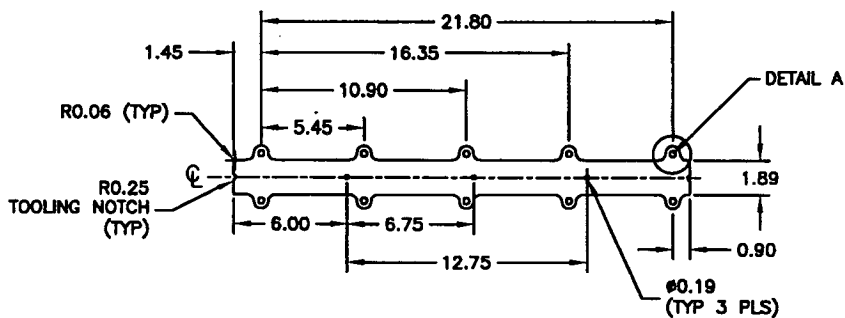
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 3 OF 6	SCALE 1:10

RELEASED
07/02/12



D3536-23 GASKET



D3536-25 GASKET

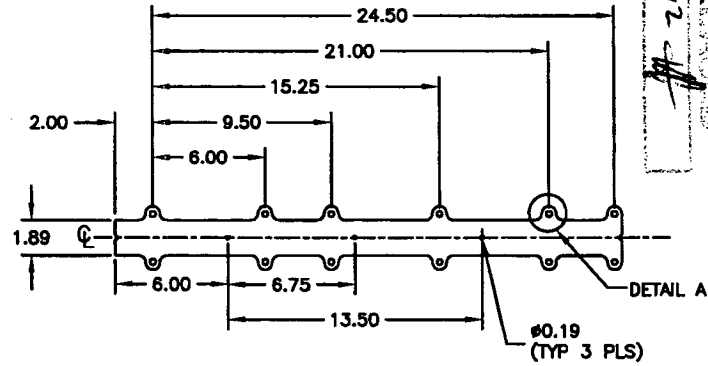
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WORK ORDER
NO. 31997

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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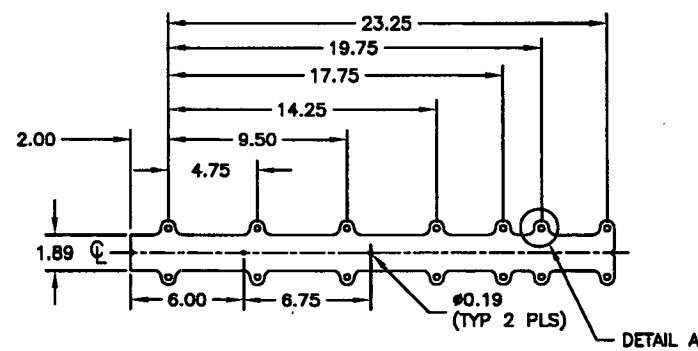
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 4 OF 6
DATE	06.10.25	TITLE	GASKET	SCALE	1:10

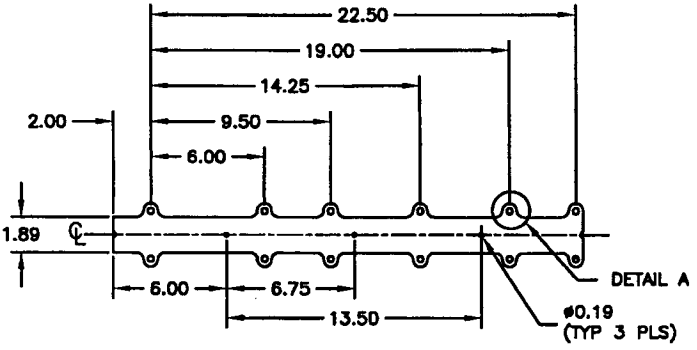
REWORKED
07.02.12



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

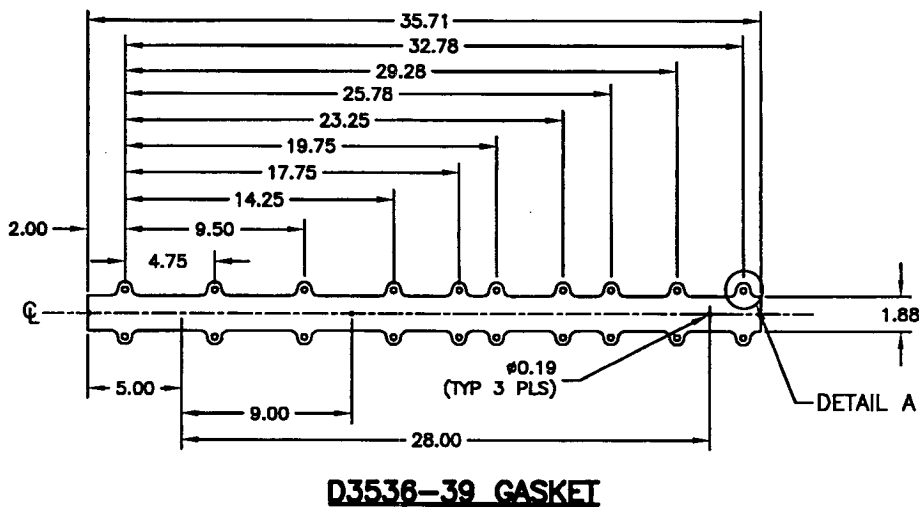
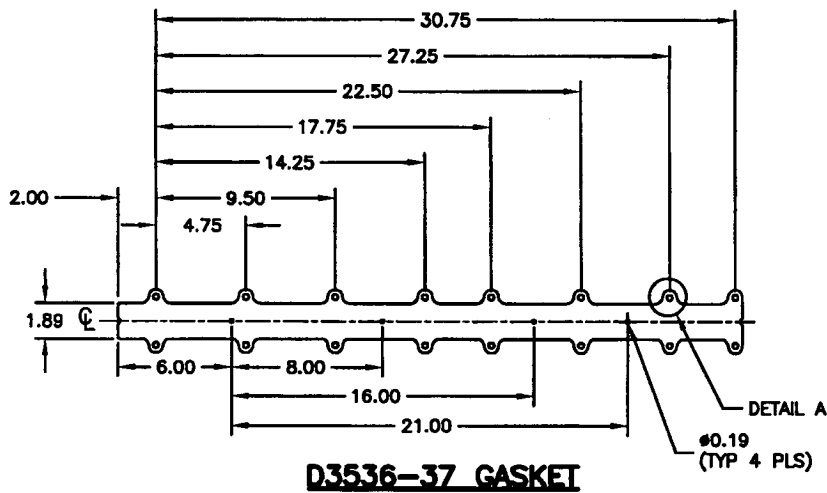
- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. A
CHECKED PH	APPROVED PH	DRAWING NO. D3536	SHEET 5 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

07.02.12
07.02.12
07.02.12




NOTES

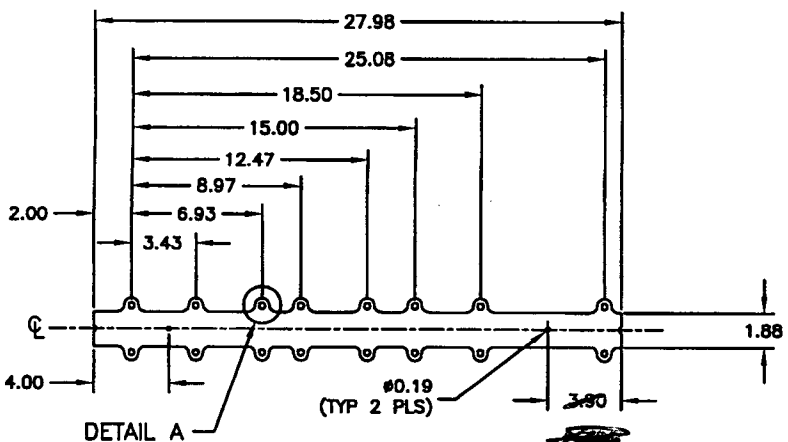
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- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH		D3536	SHEET 6 OF 6
DATE	TITLE		SCALE
06.10.25	GASKET		1:10

070212-4

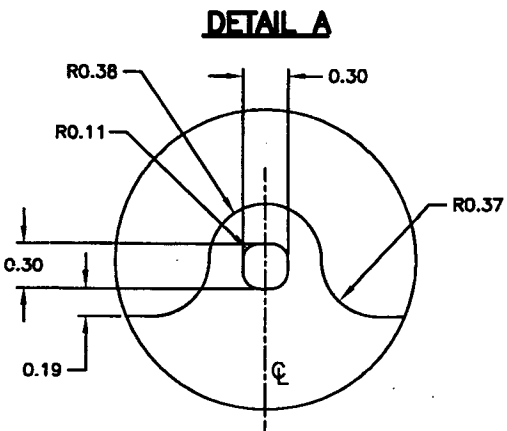


D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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WORK ORDER
NO. 31997



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DART AEROSPACE LTD		Work Order: 31997
Description: GASKET		Part Number: D3536-41
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	27.98	+/- 0.030	28.00	✓		Vern / MT	
B	25.08	+/- 0.030	25.08	✓		M-T / Vern	
C	18.50	+/- 0.030	18.50	✓		M-T	
D	15.00	+/- 0.030	15.00	✓		M-T	
E	12.47	+/- 0.030	12.480	✓		M-T Vern	
F	8.97	+/- 0.030	8.98	✓		M-T / Vern	
G	6.93	+/- 0.030	6.93	✓		Vern	
H	3.43	+/- 0.030	3.43	✓		Vern	
I	2.00	+/- 0.030	2.00	✓		Vern	
J	4.00	+/- 0.030	4.01	✓		Vern	
K	Ø 0.19	+/- 0.030	Ø 0.19	✓		Vern	
L	1.88	+/- 0.030	1.90	✓		Vern	
M	0.30	+/- 0.030	0.30	✓		Vern	
N	0.30	+/- 0.030	0.30	✓		Vern	
O	0.063	+/- 0.010	0.060	✓		Vern	
P	5.00	+/- 0.030		AA		Vern	
Q	3.90	+/- 0.030	3.90	✓		Vern	
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAV	Audited by:	Prototype Approval: N/A		
Date: 07/05/04	Date: 07.05.04	Date: N/A		
Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	